



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D3508-3**  
**Job Sheet 170950**



Part No: D3508-3

Job Qty: 8 ea

Part Name: Wearplate Fwd Center



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/24/18

Job Tracking No:

Due Date: 2/16/18

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C IPP Rev:A New Issue 06-06-20 JLM IPP Rev:B Now SS as per Rev B 06-12-15 JLM IPP Rev:C  
Rev C dwg 07-12-06 DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off       |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------------|
|       |                    |       |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |                |
| 90    | Start up Operation | 8 Ea  |            | 2/15/18  | 0.00      | 0.00    | Start Up Waterjet     |           | dc 18/01/29    |
| 100   | Waterjet           | 8 pcs |            | 2/15/18  | 0.00      | 1.12    | Waterjet1             |           | dc 18/01/29    |
| 110   | QC                 | 8 pcs |            | 2/15/18  | 0.00      | 0.00    | QC2 Waterjet-2        |           | dc 18/01/29    |
| 120   | QC                 | 8 pcs |            | 2/15/18  | 0.00      | 0.00    | QC8-2                 |           | EB             |
| 130   | Brake NC           | 8 pcs |            | 2/15/18  | 0.46      | 0.49    | Brake NC 1            |           | DAS            |
| 140   | QC                 | 8 pcs |            | 2/15/18  | 0.00      | 0.00    | QC5                   |           | 38             |
| 150   | Powdercoat         | 8 pcs |            | 2/16/18  | 0.00      | 0.20    | Powdercoat3           |           | BR 18/02/20    |
| 160   | QC                 | 8 pcs |            | 2/16/18  | 0.00      | 0.00    | QC3                   |           | 11 FEB 21 2018 |
| 170   | Packaging          | 8 pcs |            | 2/16/18  | 0.00      | 0.00    | Packaging3-1          | FP002.    | BEB 18/02/21   |
| 180   | QC21-SA            | 8 Ea  |            | 2/16/18  | 0.00      | 0.00    | QC21                  |           | cm 18/02/23    |

M 136370 START: 12:55 O.U.T: 320 FINISH: 1:025.

### Job BOM

| Part / Item | Component Name     | Quantity            | Operation             |
|-------------|--------------------|---------------------|-----------------------|
| M304S20GA   | 304/316 .040 Sheet | 5.8720 sf (.734 ea) | 90-Start up Operation |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | M304S20GA      | 6        | 158       | 0         |

### Part Specifications

Specifications could not be found.

Plex 1/24/18 1:31 PM dart.poulin.mario

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

# WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ D: \_\_\_\_\_

Work Order update only ☐

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

Date : \_\_\_\_\_  
 Desi \_\_\_\_\_

\_\_\_\_\_

| Root Cat           |                          |
|--------------------|--------------------------|
| Environment        | <input type="checkbox"/> |
| Design             | <input type="checkbox"/> |
| Doc/Data           | <input type="checkbox"/> |
| Equip/Tooling      | <input type="checkbox"/> |
| Handling/Pre       | <input type="checkbox"/> |
| Material           | <input type="checkbox"/> |
| Internal Transport | <input type="checkbox"/> |
| Tribal Knowledge   | <input type="checkbox"/> |
| LOA                | <input type="checkbox"/> |
| Substation         | <input type="checkbox"/> |
| Past Expiry Date   | <input type="checkbox"/> |
| Misidentified      | <input type="checkbox"/> |

**PART NO: D3508-3**  
**Original Serial #: S036730**  
**Revision:**  
**Operation:**  
**Change No:**

**Start up Operation 01/29/18**

**Job No: 170950**



Wearplate Fwd Center



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| AGAINST DEPARTMENT/PROCESS |                          |                     |                          |
|----------------------------|--------------------------|---------------------|--------------------------|
| Tube                       | <input type="checkbox"/> | Cross tube          | <input type="checkbox"/> |
| ning                       | <input type="checkbox"/> | Small Fab           | <input type="checkbox"/> |
| ning                       | <input type="checkbox"/> | Finishing           | <input type="checkbox"/> |
| : Fab                      | <input type="checkbox"/> | Composite           | <input type="checkbox"/> |
|                            |                          | Water Jet           | <input type="checkbox"/> |
|                            |                          | Prod. Eng. Coord.   | <input type="checkbox"/> |
|                            |                          | Rec/Store/Packaging | <input type="checkbox"/> |
|                            |                          | Supplier            | <input type="checkbox"/> |
|                            |                          | Engineering         | <input type="checkbox"/> |
|                            |                          | Quality             | <input type="checkbox"/> |
|                            |                          | Other               | <input type="checkbox"/> |

Effective : \_\_\_\_\_  
 Disposition \_\_\_\_\_

MRB (QSI042) Approval \_\_\_\_\_  
 Completed By \_\_\_\_\_  
 Lead hand / Supervisor Approval Verification \_\_\_\_\_  
 QC / QA Coordinator Approval \_\_\_\_\_

## FAULT CATEGORY

|                                                |                                               |
|------------------------------------------------|-----------------------------------------------|
| <input type="checkbox"/> Power Loss/Surge      | <input type="checkbox"/> Positioned Wrong     |
| <input type="checkbox"/> Folio/Program         | <input type="checkbox"/> Outside Dimensions   |
| <input type="checkbox"/> Grain                 | <input type="checkbox"/> Over/Under tolerance |
| <input type="checkbox"/> Weld                  | <input type="checkbox"/> Part Incorrect       |
| <input type="checkbox"/> Wrong Stock Pulled    | <input type="checkbox"/> Part Lost/Missing    |
| <input type="checkbox"/> Out of Sequence       | <input type="checkbox"/> Part Moved           |
| <input type="checkbox"/> Off-set               | <input type="checkbox"/> Drawing              |
| <input type="checkbox"/> Mislabeled            | <input type="checkbox"/> Finish               |
| <input type="checkbox"/> Fit/Function          | <input type="checkbox"/> Misread              |
| <input type="checkbox"/> Misaligned/off center | <input type="checkbox"/> Turning Sequence     |

☐ Rushing  
☐ Heat Treat  
☐ Product Improvement  
☐ Wave/Twist in Tube  
☐ Process Improvement  
☐ Marks/Chatter  
☐ Manufacturing Process  
☐ Past Due

OTHER :



|                                     |  |                     |         |
|-------------------------------------|--|---------------------|---------|
| <b>DART AEROSPACE LTD</b>           |  | <b>Work Order:</b>  | 170950  |
| <b>Description: Wearplate</b>       |  | <b>Part Number:</b> | D3508-3 |
| <b>Inspection Dwg: D3508 Rev: C</b> |  | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 2.063             | +/-0.010      | 2.070            | 1      |        |                      |          |
| 2.813             | +/-0.010      | 2.810            | 1      |        |                      |          |
| 0.375             | +/-0.010      | 0.370            | 1      |        |                      |          |
| 5.625             | +/-0.010      | 5.626            | 1      |        |                      |          |
| 33.750            | +/-0.010      | 33.750           | 1      |        |                      |          |
| 37.13             | +/-0.030      | 37.13            | 1      |        |                      |          |
| Ø0.188            | +0.005/-0.001 | Ø.189            | 1      |        |                      |          |
| 0.300             | +/-0.010      | 0.301            | 1      |        |                      |          |
| 0.300             | +/-0.010      | 0.302            | 1      |        |                      |          |
| 0.038             | +/-0.010      | 0.036            | 1      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
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|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                     |          |                    |             |                            |     |
|---------------------|----------|--------------------|-------------|----------------------------|-----|
| <b>Measured by:</b> | dc       | <b>Audited by:</b> | JS          | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b>        | 18/01/20 | <b>Date:</b>       | FEB 01 2018 | <b>Date:</b>               | N/A |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 08.04.15 | New Issue | KJ/DD      | JS       |